

Work Order ID 86098

86098

Page 1

June-20-12 2:48:52 PM

Item ID: D3048-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Doubler

Stop

NS2

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 20/06/12

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3048	Rev A2

100 0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3048 Dwg Rev: A2 Prog Rev: A2 2-
Deburr if necessary

2024.063

B12-6-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-6-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/12/06/12

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Form on CNC Brake per Dwg D3048								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

PTO

28 13/04/11

1 28 13-4-11

OAS
27
2.6

13 4 11

W/O: 86098

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3048-1 PAR #: Fault Category: Sum Tab NCR: Yes No DQA: Lat Date: 13/04/20
 Resolution: 13.2504 Disposition: Scrap QA: N/C Closed: off Date: 13/4/16

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
13/04/11	120	1 part was scrap out of tolerance P.C. <u>operator error.</u> <u>Process</u>	DAS 16 2-30 257042 13/04/11	Scrap & destroy No replace	SB 13/04/11	<u>27</u> B-4.11	DAS 16 2-30 257042 13/04/11	DAS 16 2-30 13/04/11

NOTE: Date & initial all entries

86098

June-20-12 2:48:52 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Doubler

Start Date: 20/06/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 04/07/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Identify as per dwg & Stock Location: Valentin 0.00

160

Packaging

Packaging

Memo

0.00

CL 13/04/12 (1)

170	QC21- Final Inspection - Work Order Release	0.00
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170

QC

Quality Control

Memo

0.00

13/4/15

PL 13-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86098

86098

Parent Item: D3048-1

D3048-1

Parent Item Name: Doubler

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A 02.11.19 New issue KJ/RF
IPP Rev:B Now on Waterjet 06-10-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063		Purchased	No			100	sf	268.9700	3.4583	7.280632	②	7.5	
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M2024T3S 063

**

2024-T3 .063 sheet

R/LC-X

Location

Loc Qty

Loc Code

MAT022

268.97

119916

73.27

121197

195.7

121197

W/O:		WORK ORDER CHANGES					
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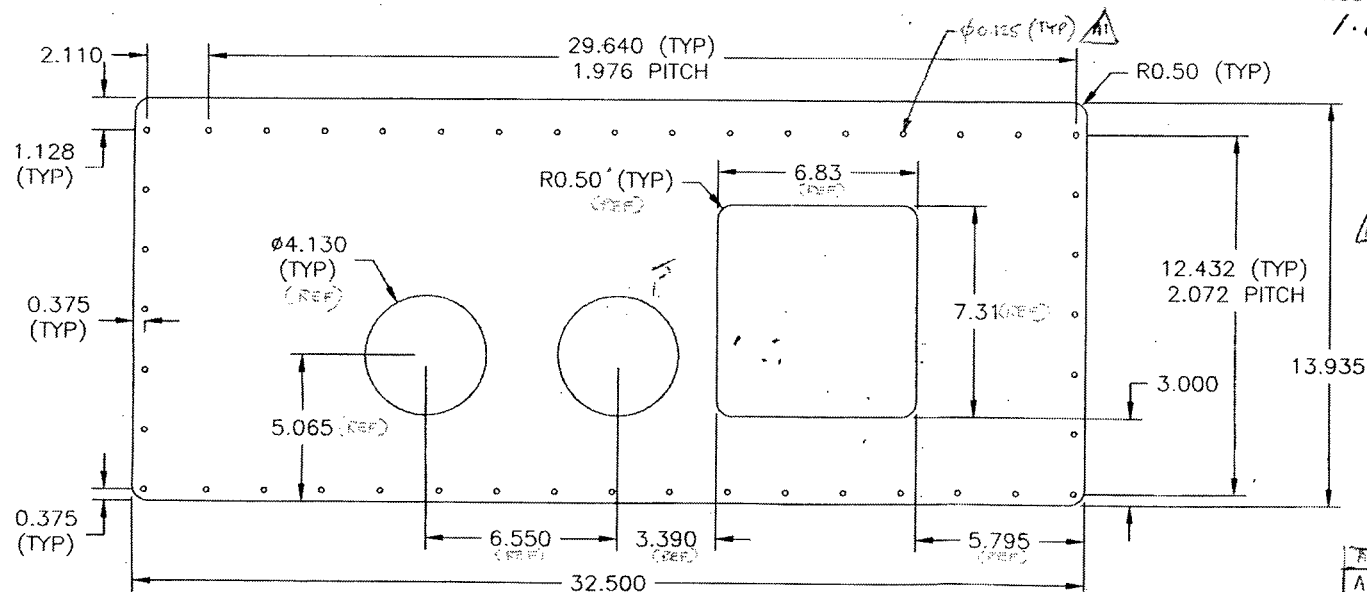
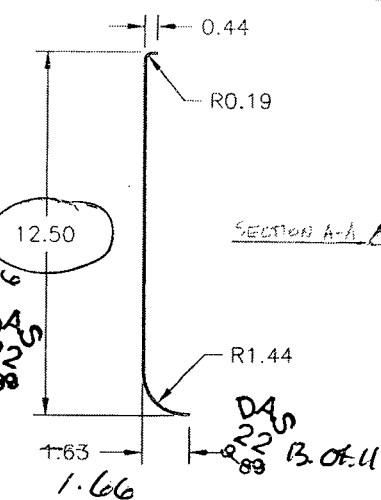
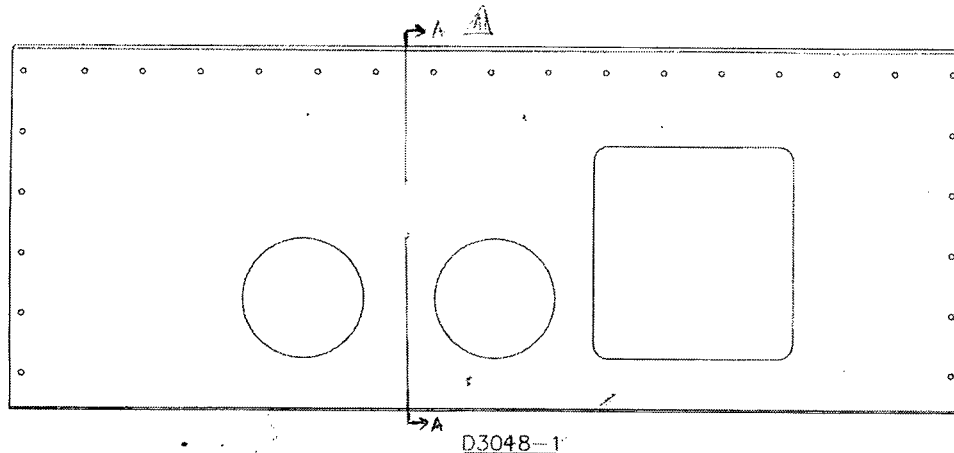
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3048-1 FLAT PATTERN

MATERIAL: 2024-T3 (QQ-A-250/4)
0.063 THICK
FINISH: ACID ETCH, ALODINE PER DART
QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

△ CUM. QTY. (SHEET) ARE SHOWN FOR REFERENCE ONLY,
DO NOT CUT.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20098 MLJ

12/06/20

RELEASED
01.34.27

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DART AEROSPACE LTD.

REV.	DATE	DESCRIPTION
A1	02.11.20	CORRECT DWG ERRORS
A	01.09.25	NEW ISSUE
DESIGN	DRAWN BY RF	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3048
DATE 01.09.25		TITLE DOUBLER

REV. A
SHEET 1 OF 1
SCALE
1:4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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